

Work Order ID 54878

January 04, 2010 1:22:03 PM



Page 1

Item ID: D3685-041

Accept



Setup Start



Revision ID:

Item Name: BIPOD MOUNT ASSEMBLY 3 MP

Start Date: 1/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MP

Date: 10-01-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3685	Rev C
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100	Pick Kit	0.00							
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Packaging	Memo	0.00							
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Packaging									
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110	Small Fab	0.00							
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Small Fab	Memo	0.00							
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Small Fab	1-Use anti-seize compound Tectyl 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685								
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2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating
surfaces as per Dwg D3685

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3685

SB 10/01/24

(3)

SB 10/01/24

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



Start Date: 1/5/2010 Start Qty: 2.00



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

→ 10/01/26

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

10-1-26 (3) Sf

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/01/27 (1)

MF 10-1-27

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Picklist Print

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Work Order ID: 54878



Parent Item: D3685-041



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/26/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3C12A



Purchased

No

110

Each

350.0000

8.0000

Bolts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

350

112314

350

12

88 10/01/24

D3684-047



Manufactured

No

110

Each

1.0000 2.0000

FWD LEG ASS'Y

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST B54875

1

45600

1

3

88 10/01/24

D3684-049



Manufactured

No

110

Each

4.0000 2.0000

AFT LEG ASS'Y

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

B54874

4

45601

1

48169

3

3

88 10/01/24

W/O:		WORK ORDER CHANGES					
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Parent Item: D3685-041



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/26/2010

Comments:

Start Qty: 2.00

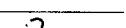
Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-3  MOUNT		Manufactured	No			110	Each	14.0000	2.0000			

Warehouse

Location

Main Warehouse

ST	8	
45912	2	
46761	6	

SB 10/01/26

Main Warehouse

ST118	6	
51096	6	

D3692-1



SPACER

Manufactured

No

110

Each

642.0000 16.0000



Warehouse

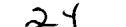
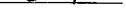
Location

Main Warehouse

ST	55	
44827	8	
45672	14	
50325	33	

SB 10/01/26

Main Warehouse

ST127	587	
50736	179	
51467	408	

W/O:		WORK ORDER CHANGES					
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Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/26/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased		No		110	Each	4,542.000	8.0000			

Nut

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE FG	80	
103691	80	
Main Warehouse ST	4462	
111819	70	
112243	29	
112314	4363	

SP 10/21/26

W/O:		WORK ORDER CHANGES					
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8

7

6

5

4

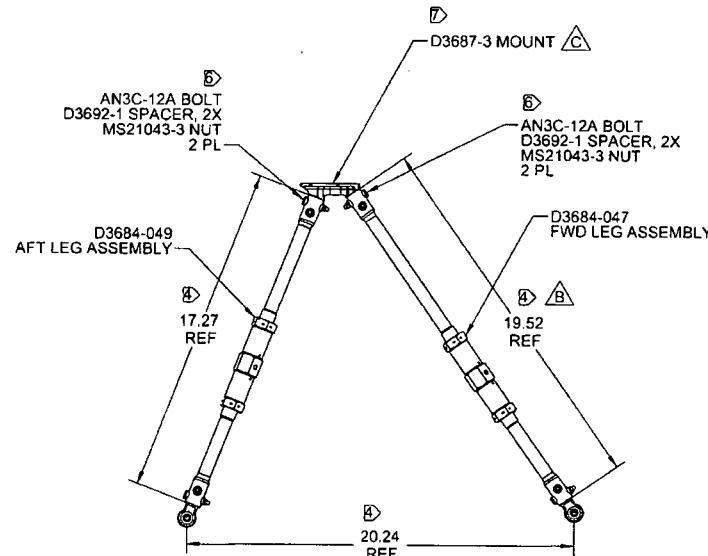
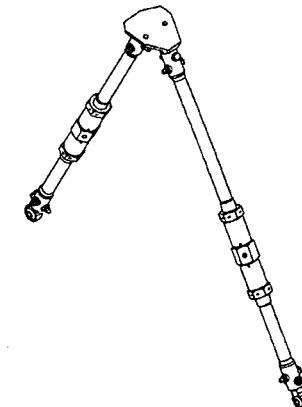
3

2

1

#54878

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	REV. C		
CHECKED	DRAWING NO. D3685		
MFG. APPR.	REV. 1 OF 1		
APPROVED	TITLE BIPOD MOUNT ASSEMBLY		
DE APPR.	SCALE NTS		
DATE 08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

RELEASED
09/01/11 MM

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